

Date: Monday, 12/01/2009 2:29:07 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 44548	
Estimate Number : 10313	
P.O. Number :	Part Number : D26483
This Issue : 12/01/2009 S.O. No. :	Drawing Number : D2648 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 44322	Material :
Written By :	Due Date : 30/01/2009 Qty: 40 Um: Each
Checked & Approved By : <u>JULIA DAWSON</u>	
Comment : Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF Est Rev:F Now on Waterjet 06-08-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025 sheet 16GA
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Comment: Qty.: 0.0788 sf(s)/Unit Total : 3.1500 sf(s)
 1010/1025/A21/6aA SHEET
 (M1010S16GA)
 Batch: 105706 B 9-2-2

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2648
 *****CUT WITH FILE D2648-1*****
 Dwg Rev: D
 Prog Rev: D B 9-2-2
 2-Deburr if necessary B 9-2-2

(44)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

509/02/02 counts x44

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

1/5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.
2-Identify as D2648-3

SB 09/02/03

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R560Hardcoat M109479
1-Weld as per Dwg D2648 using Jig DT 8210
2-Remove any weld that penetrated through Wearpadif necessary

EL 9-2-12

8.0	QC10	VISUAL INSPECTION OF GROUND WELDS
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Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/02/12 (X44)

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/02/12 (X44) contio

10.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109648

START TIME:

12:55

OVEN TEMPERATURE:

320°

FINISH TIME:

1:25

BR 09-02-12

(44)

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/12 (44)

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-16

BL 09-02-12 (44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEARPAD

Job Number: 44548

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/13
JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0.220 X 0.300
OBROUND
(4 PLS)

R0.375

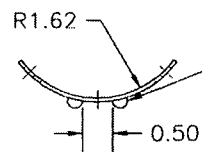
R0.375

R0.128 (TYP)

1.965

2.715


3.500



Technical drawing of a mechanical part showing dimensions and surface finish requirements. The drawing includes the following labels and dimensions:

- LDS**: Label for the top surface.
- CK**: Label for the side surface.
- R1.62**: Dimension for the top radius.
- 0.12 (TYP)**: Dimension for the width of the top surface.
- 0.13** and **0.10**: Dimensions for the width of the side surface.
- D2941-300**: Surface finish specification.
- REMOVE POWDER COAT FROM THESE SURFACES**: Instruction for surface preparation.

RELEASE
94-2-20 05

D	99.11.17	ADDED D2648-7	
C	97.06.26	R31.6 WAS R19.6	
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250	
A	97.03.25	NEW ISSUE	
DESIGN #	DRAWN BY RF	 DART DART AEROSPACE USA, INC. BELLEVILLE, ILL.	
CHECKED #	APPROVED #	DRAWING NO. D2648	REV. SHEET 1 OF 1
DATE 99.11.17		TITLE WEARPAD	SCALE 1: